



Selectarc 309HR

*Stainless Electrode
With high efficiency*

Classification

AWS A5.4 : E309L-26 EN 1600 : E 23 12 L R 7 3
ISO 3581-A : E 23 12 L R 7 3

Description & Applications

Synthetic electrode with high recovery (160%). Rutile-basic coating with a 24%Cr-13%Ni stainless steel type deposit. Used when a high efficiency is desired. For buffer layers before hardfacing and for dissimilar joints - stainless steels to ordinary steel....

Base materials

Stainless steels for general use and for high temperature applications:

UNS	Alloy	EN	Material N°	UGINE
S30900	309	X15CrNiSi20-12	1.4828	UGINOX R20-12
S30453	304 LN	X2CrNiN18-10	1.4311	
S30908	309S	X12CrNi23-13	1.4833	UGINOX R24-13S
		X10CrSi6	1.4712	
		X10CrAl18	1.4742	

+ all mild steels and low alloyed steels in combination with stainless steels.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Fe
<0.04	0.9	0.7	22.5	12.5	Rem.

All Weld Metal Mechanical Properties

Rp0.2 (MPa)	Rm (MPa)	A5 (%)	KV (J)
>400	>560	>35	+20°C >50

Welding Current & Instructions

Electrode	ØxL (mm)	2,0x350	2,5x350	3,2x350	4,0x450
Current	(A)	65	90	130	170

Redrying 1 hour at 250°C, if necessary. Interpass temperature : < 150°C.

ind.12



= + ~ 50V



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